

Date: Wednesday, 5/31/2006 7:40:26 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT BRACKET
<b>Job Number</b> : 27309	
<b>Estimate Number</b> : 10260	
<b>P.O. Number</b> : NIA	<b>Part Number</b> : D23623
<b>This Issue</b> : 5/31/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : D2362 REV E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : NIA <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E1
<b>Previous Run</b> : 25451	<b>Material</b> : NIA
<b>Written By</b> : SEE COMMENT Below	<b>Due Date</b> : 6/25/2006
<b>Checked &amp; Approved By</b> : [Signature] 06-05-31	<b>Qty</b> : 20 <b>Um</b> : Each
<b>Comment</b> : Est: G 00.0518 Added inspection level 8 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2265	Step Support Casting
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
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1	D2265	Step Support	B25401
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MS 06/06/01

20  
10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** Machine per folio D2362-3

JL 06/06/02 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** Inspect Level 2

JL 06/06/02 20

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

MS 06/06/02 20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

JL 06/06/02 20

6.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

A.M 06-06-06

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:40:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 27309

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

(10)

B 27312

(10)

B 27401

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

(10)

B 27313

(10)

B 27402

SB 06/04/07

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch M16194

m.p. 06/06/07 (20)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57172

06/06/08 (20)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/08 (20)

Job Completion



06/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



**DART**



**RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

**UNDER REVIEW**

98.03.15 CP

DESIGN OK, BUT CHECK WITH  
3B BEFORE MANUFACTURE  
OK 9/04/07

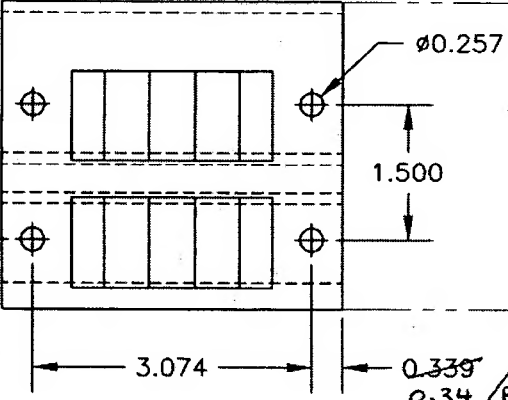
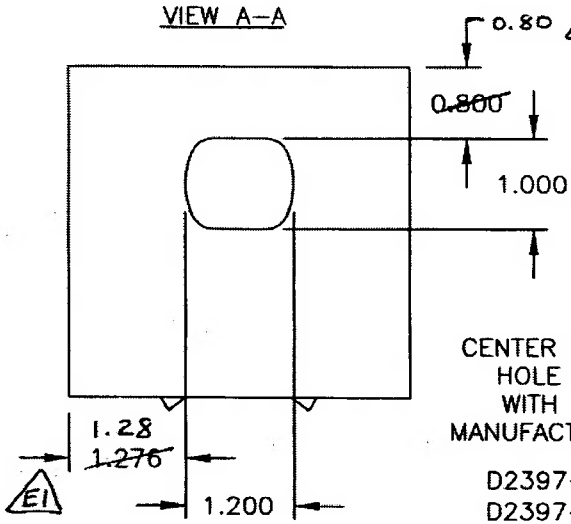
0.257 X 0.75 SLOT

REMOVE TIPS  
FROM CASTING  
MAX 0.080

CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)

VIEW A-A



**D2362-3**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBMIT TO APPROPRIATE  
WITHOUT NOTICE  
WORK ORDER

**NOTES:**

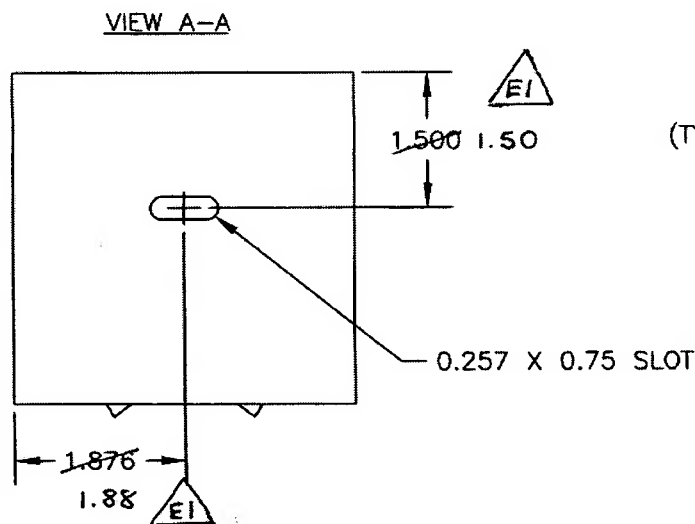
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED JH	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3 SCALE 1:2

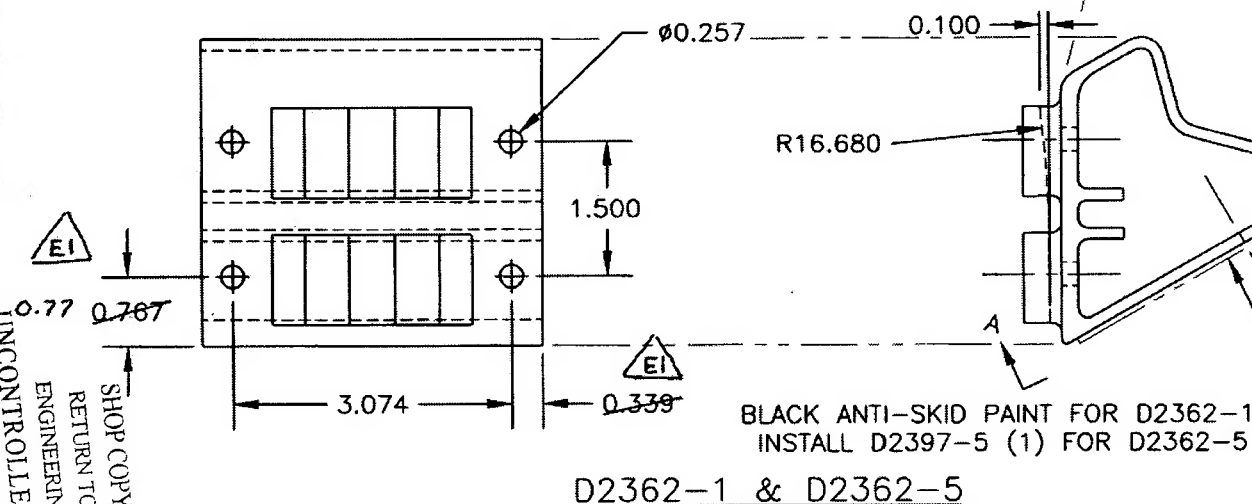
RELEASED  
98.12.14  
UNDER REVIEW  
KE

DESIGN OK, BUT CHECK BY  
OR BEFORE MANUFACTURE  
OK 10/1/05



MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT  
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 27309

D2362-041 (SHOWN)

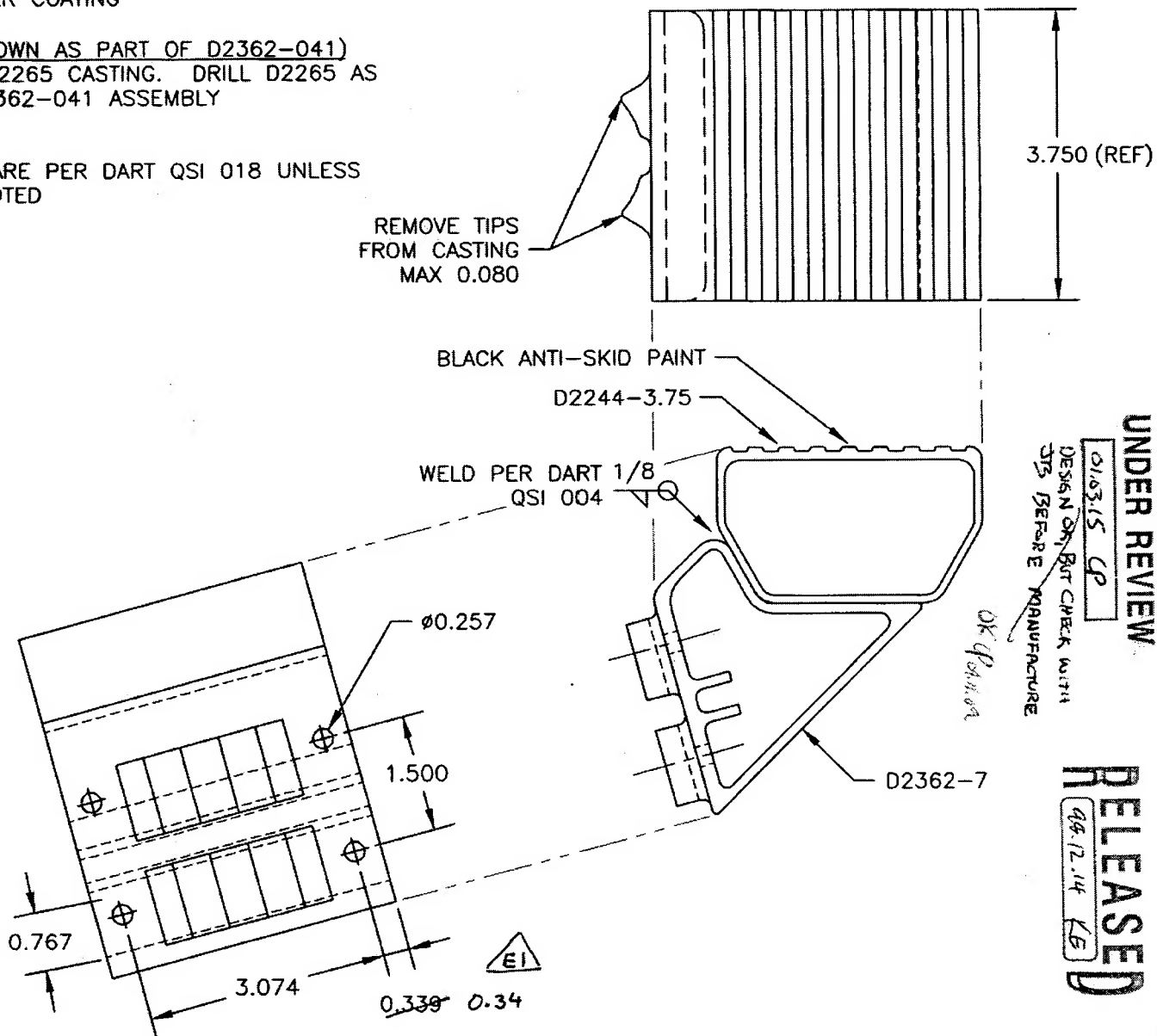
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

**NOTES:**

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2362
DATE	TITLE	SHEET 3 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

UNDER REVIEW

01.03.15 CP

DESIGN ON BUT CHECK WITH  
DTS BEFORE MANUFACTURE

RELEASED  
98.12.14 KE

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